

Work Order ID 76891

November-23-11 10:55:57 AM

76891

Page 1

Item ID: D4131-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Manifold Assembly

Start Date: 11/23/11 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/23/11 Req'd Qty: 2.00 ***2***

Customer:

Reference: ECN11-639 **REWORK**

Approvals: Process Plan: *[Signature]* Date:

Run Start ***NR1***

QC: *[Signature]* Date:

Stop ***NR2***

Tooling:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr Revision Nbr

D4131 B

105

0.00

105

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:

2 X D4131-041 B71412

REWORK D4131-041 PER ECN11-639

ADD D4131-9 TO PART PER REV.B

EP 12/02/15 (2)

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

So 12/02/15 (2)

Work Order ID 76891

November-23-11 10:55:57 AM

76891

Page 2

Item ID: D4131-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Manifold Assembly

Start Date: 11/23/11 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/23/11 Req'd Qty: 2.00 ***2***

Customer:

Reference: ECN11-639

Approvals: Process Plan: Date:

Run Start ***NR1***

QC: Date:

Tooling: Date:

Stop ***NR2***

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 132

0.00

130

Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

12/16/11

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/16/11

12-02-14

Picklist Print

November-23-11 10:55:57 AM

Page 1
↑

Work Order ID: 76891

Parent Item: D4131-041

Parent Item Name: Manifold Assembly

Start Date: 11/23/11

Required Date: 11/23/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC
REV.B DD verf:EC

IPP Rev:B 11.09.26 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4131-041 Manifold Assembly		Manufactured	No				Each	0.0000		2		12/02/15	
D4131-9 Label Plate		Manufactured	No				Each	63.0000		2		12/02/15	

Location

Loc Qty

Loc Code

GA

63

74258

3

74267

24

75067

36

MS20615-3M3

Purchased

No

Each

100.0000

RIVET

Location

Loc Qty

Loc Code

ST323

100

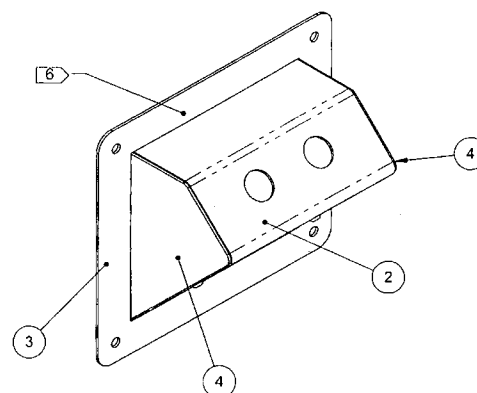
119108

100

2
2
4
4

12/02/15
12/02/15
12/02/15
12/02/15

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4131-041	MANIFOLD ASSEMBLY
2	1	D4131-045	BASE ASSEMBLY
3	1	D4131-1	FRONT PLATE
4	2	D4131-5	SIDE PLATE



D4131-041 MANIFOLD ASSEMBLY

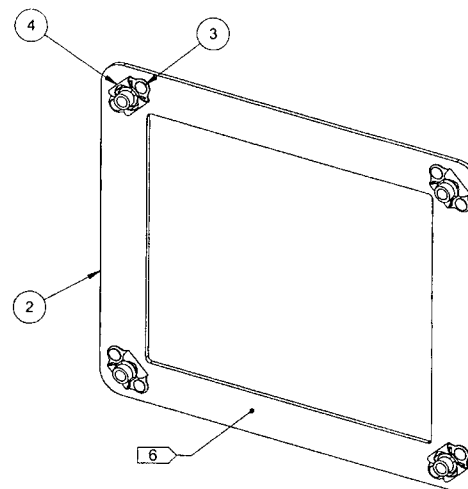
RELEASED
2011-09-21
W/P

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs

B	D4131-045 WAS D4131-3 (ZN D3-1); ADD 4131-045 (ZN B4-3); ADD Ø0.098 (ZN B4-7); ADD 4131-9 (ZN B5-10)	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	W/P	DRAWING NO.	REV. B
MFG. APPR.	SS	D4131	SHEET 1 OF 10
APPROVED	W/P	TITLE	SCALE
DE APPR.	W/P	MANIFOLD ASSEMBLY	NTS
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4131-043	DOUBLER ASSEMBLY
2	1	D4131-7	DOUBLER
3	8	MS20426AD3-3	RIVET
4	4	MS21069L3	NUT PLATE



D4131-043 DOUBLER ASSEMBLY

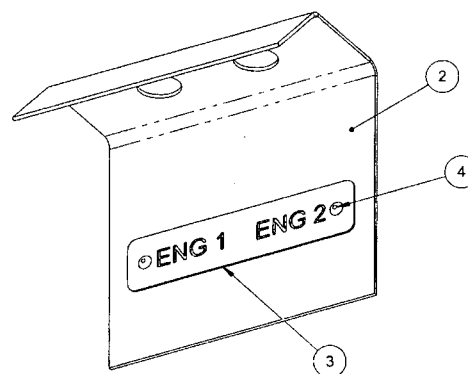
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

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2011-09-21
JAN

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MFG. APPR.	<i>MP</i>	D4131	SHEET 2 OF 10
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4131-045	BASE ASSEMBLY
2	1	D4131-3	BASE
3	1	D4131-9	LABEL PLATE
4	2	MS20615-3M3	RIVET



D4131-045 BASE ASSEMBLY

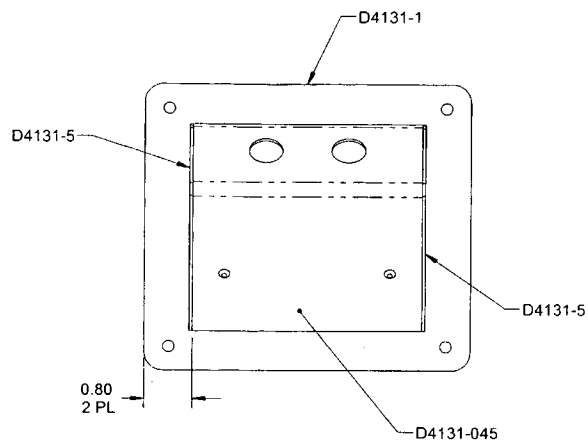
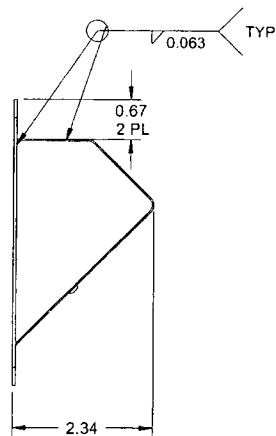


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NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 3 OF 10
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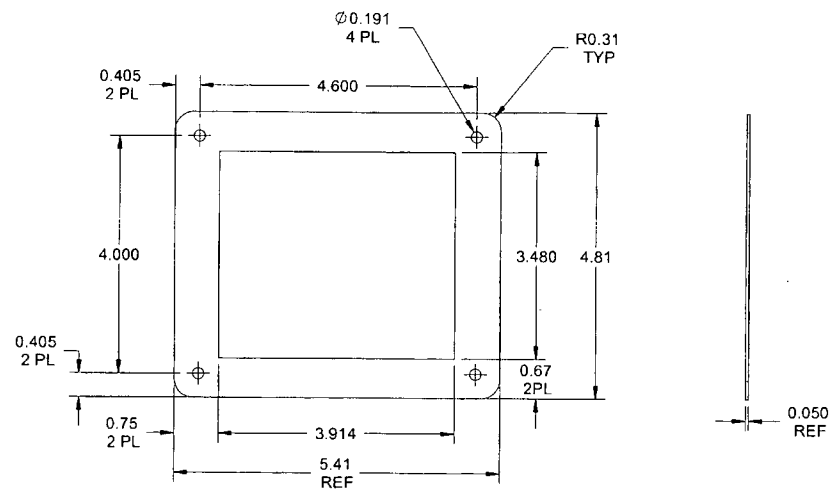
D4131-041 MANIFOLD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.66 lbs
- 8) WELD PER DART QSI 004

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MFG. APPR.	<i>RF</i>	D4131	SHEET 4 OF 10
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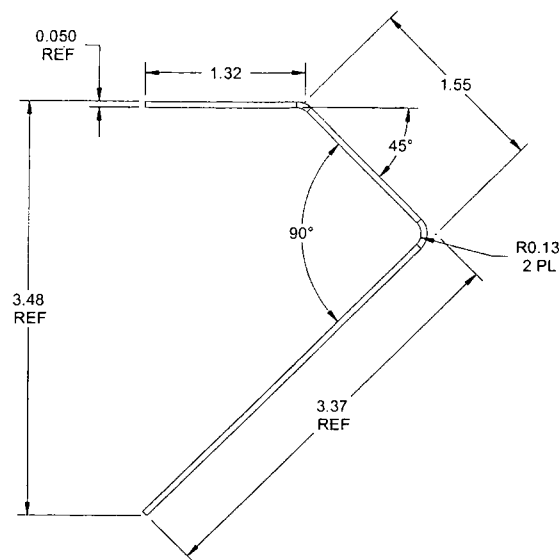
D4131-1 FRONT PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 5 OF 10
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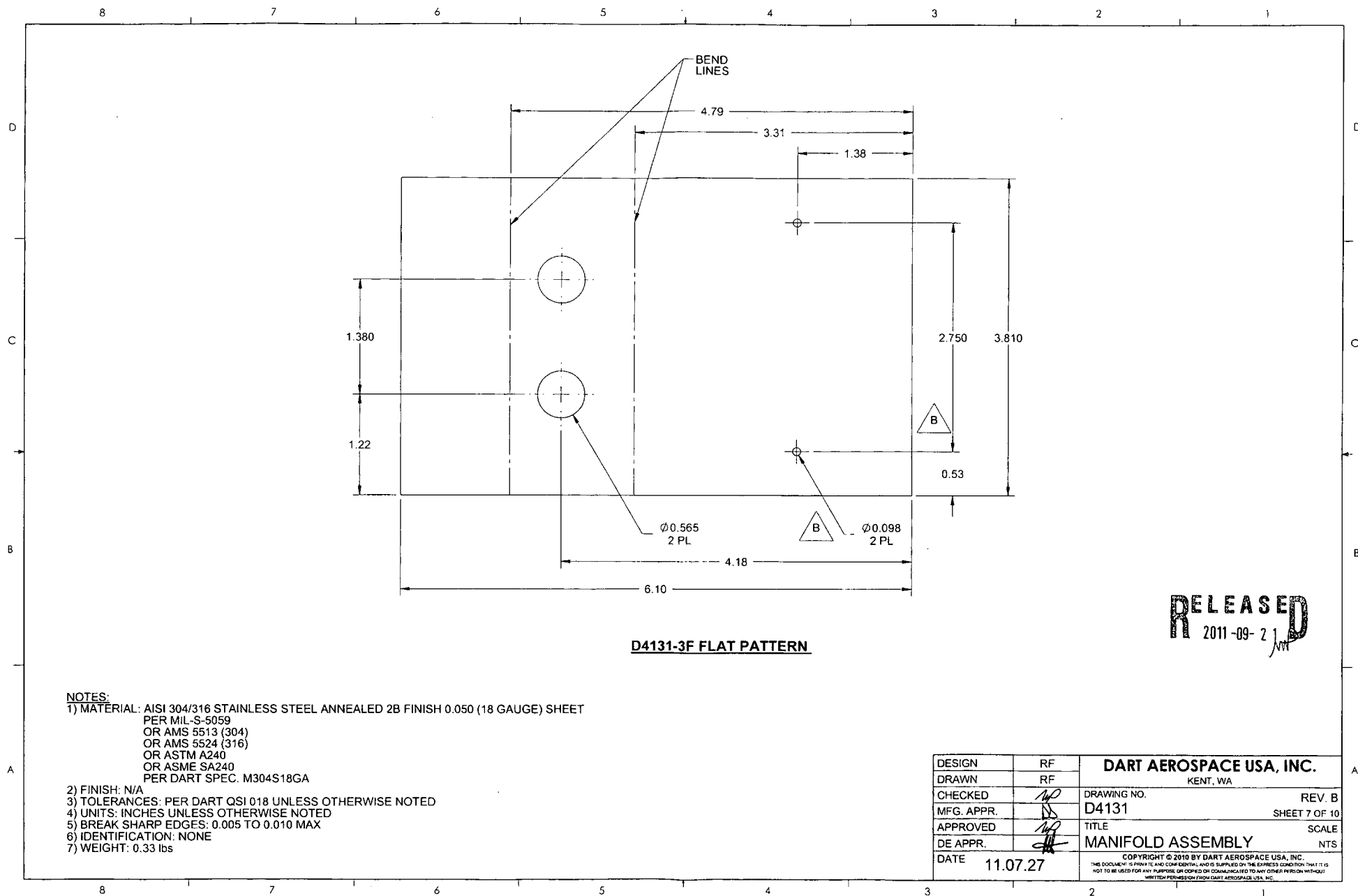


D4131-3 BASE
MAKE FROM D4131-3F FLAT PATTERN

RELEASED
2011-09-21
VW

- NOTES:**
- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 6 OF 10
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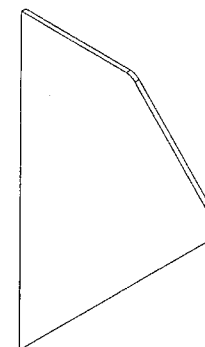
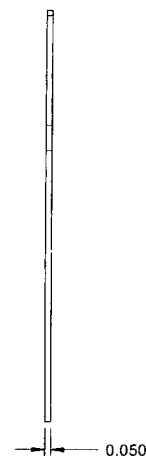
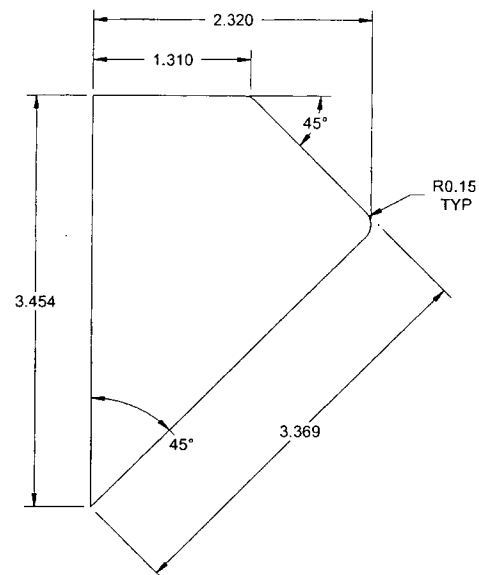


NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

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MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 7 OF 10
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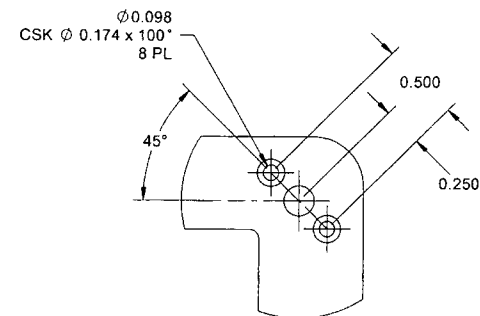
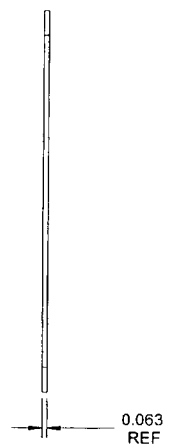
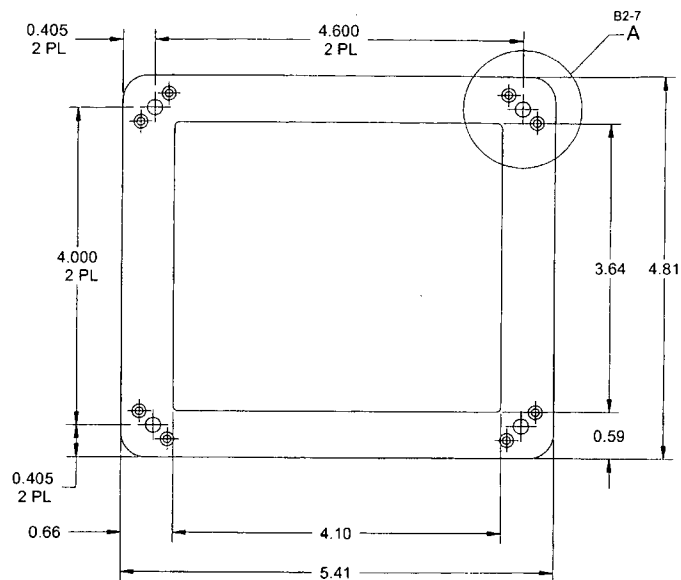
D4131-5 SIDE PLATE

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2011-09-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4131	SHEET 8 OF 10
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DETAIL A D5-7
TYPICAL

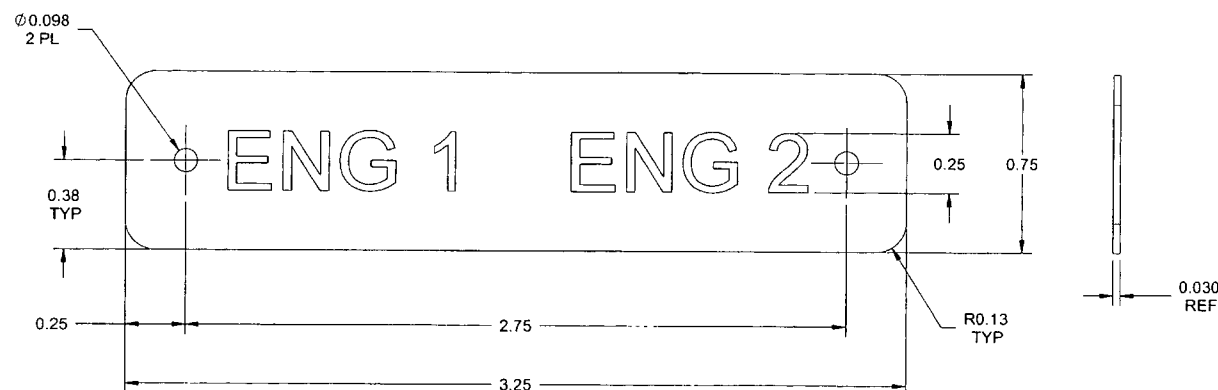
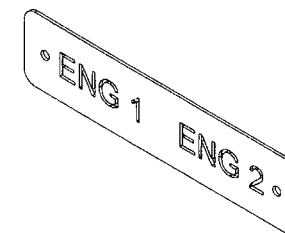
D4131-7 PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS4027
OR ASTM B209
PER DART SPEC. M6061T6S0.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

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2011-09-21

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4131	SHEET 9 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MANIFOLD ASSEMBLY	NTS
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D4131-9 LABEL PLATE

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2011-09-21
MP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.030 (22 GAUGE) SHEET
PER MIL-S-5059
OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240
OR ASME SA240
PER DART SPEC. M304S22GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4131	SHEET 10 OF 10
APPROVED	<i>RF</i>	TITLE	SCALE
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